

CLAIMS

1. A method of vulcanization-molding a rubber material by heating a vulcanization mold and pushing the rubber material onto a shaping face of the mold through a pressure supplied to an interior of the mold, wherein a low-  
5 pressure fluid is supplied to the interior of the mold at an initial stage of the vulcanization molding and thereafter the pressure of the fluid is increased stepwise or stepless.

2. A method of vulcanization-molding a rubber material according to claim 1, wherein a low-temperature fluid is supplied to the interior of the  
10 vulcanization mold at the initial stage of the vulcanization molding and thereafter the temperature of the fluid is increased stepwise or stepless.

3. A method of vulcanization-molding a rubber material according to claim 1 or 2, wherein two fluids having different pressures and temperatures are selectively supplied to the interior of the vulcanization mold.

15 4. A method of vulcanization-molding a rubber material according to any one of claims 1 to 3, wherein after the supply of the fluids to the interior of the vulcanization mold, an inert gas having a pressure higher than those of the fluids is supplied to the mold.

5. A method of vulcanization-molding a rubber material according  
20 to any one of claims 1 to 4, wherein the fluid is a steam, a warm water or a hot air.

6. A method of vulcanization-molding a rubber material according to any one of claims 1 to 5, wherein a time at the initial stage of the vulcanization molding is within a range of 0.5-3 minutes and a pressure of a steam supplied to  
25 the vulcanization mold in such a time is within a range of 0.5-1.0 MPa.